

**Work Order ID 73497**

Thursday, September 01, 2011 12:34:17 PM



Page 1

Item ID: D3552-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Prop

Start Date: 9/1/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: *V*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3552	H

100



PURCHASING

Purchasing

Memo

0.00

Issue P/O: *14805*

Purchase Part Number: B6-220-530-140N

Supplier: LS Technologies

Certificate of conformity is required

*CL 11/09/01 16*

110



Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

*10/2/11 (16)*

120



QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

Test for correct pressure

*S. Morales*
*(146)*
*DKB*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		QTY of all door panels were found at inspection to be about 11" too short. (measure 20.9" should be)						

NOTE: Date & initial all entries

**Work Order ID 73497**

Thursday, September 01, 2011 12:34:17 PM



Page 2

Item ID: D3552-13

Accept



Setup Start



Revision ID:

Item Name: Door Prop

Stop



Start Date: 9/1/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

130



Packaging

Identify as per dwg & Stock Location: *SD271*

Packaging

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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*(16k)*
*11-09-08*
*11/9/12 JG*
*MF 11-09-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, September 01, 2011 12:34:14 PM

Page 1

Work Order ID: 73497



Parent Item: D3552-13



Parent Item Name: Door Prop

Start Date: 9/1/2011

Required Date: 9/8/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A new issue DD 10.02.17 verified by:EC  
10.12.03 as per dwg rev.G DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B6-220-530-140N		Purchased		No		110	Each	0.0000	1	16			

Door Prop



9/1/11 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

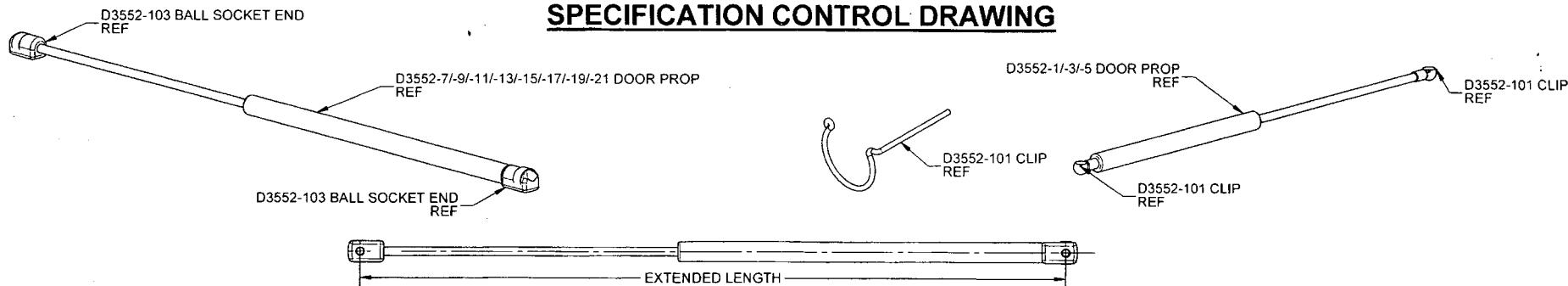
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## SPECIFICATION CONTROL DRAWING



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER	ALTERNATE SUPPLIER	ALTERNATE SUPPLIER P/N OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N	N/A	N/A
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N	N/A	N/A
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N	N/A	N/A
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N	N/A	N/A
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N	N/A	N/A
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N	N/A	N/A
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N	N/A	N/A
D3552-15	DOOR PROP	139/5.47	386/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300N	SUSPA, Inc.	16-2-210-139-A101-B101-400N
D3552-17	DOOR PROP	139/5.47	386/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156N	SUSPA, Inc.	16-2-210-160-A101-B101-156N
D3552-19	DOOR PROP	139/5.47	386/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060N	SUSPA, Inc.	16-2-210-139-A101-B101-060N
D3552-21	DOOR PROP	167/6.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-167-410-070N	N/A	N/A
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9	N/A	N/A
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10	N/A	N/A

### D3552-X DOOR PROP

W023497

RELEASED  
2011-08-16

- NOTES:
- 1) IDENTIFICATION: IDENTIFY PER QSI 044 6.2
  - 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
  - 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21 DOOR PROPS

DESIGN	LE	DART AEROSPACE LTD
DRAWN	PC	HAWKESBURY, ONTARIO, CANADA
CHECKED	BR	DRAWING NO.
MFG. APPR.	N/A	REV. H
APPROVED	SH	D3552
DE APPR.	SH	SHEET 1 OF 1
DATE	11.03.10	TITLE
		DOOR PROP
SCALE		
NTS		
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO14805

Purchase Order Date 9/1/2011

PO Print Date 9/1/2011

Page Number 1 of 2

Order From : VC-LST0001

LS TECHNOLOGIES INC.  
303-103 STREET  
SASKATOON, SK S7N 1Y9  
CA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

RECEIVED  
CL 10/9/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B8-220-530-070N	CARBON STEEL GAS SPRING	9/7/2011 Yes	12.00 Each	FedEx PI collect	\$36.8500	\$442.20
			Special Inst:	AS PER DWG D3552 REV. H B73382			
2	B6-220-530-140N	Door Prop	9/7/2011 Yes	16.00 Each	FedEx PI collect	\$36.8500	\$589.60
			Special Inst:	AS PER DWG D3552 REV. H B73497			
3	BS104	BALL STUD	9/7/2011 Yes	20.00 Each	FedEx PI collect	\$1.1200	\$22.40
			Special Inst:	AS PER DWG D3554 REV. A B73383			
4	SSA4/6-122-315-310N	Gas Spring	9/7/2011 Yes	20.00 Each	FedEx PI collect	\$65.0000	\$1,300.00
			Special Inst:	AS PER DWG D3969 REV. C B73523			

LS Technologies Canada Inc.

303 - 103 Street  
Saskatoon, SK Canada  
S7N 1Y9

# Packing Slip

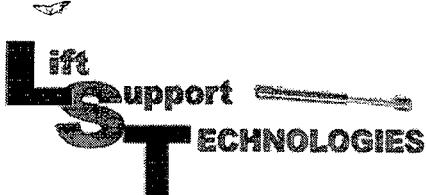
Date	Invoice #
9/6/2011	7653

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
PO14805	9/2/2011	Fed-Ex		

Qty	Description
12	B8-220-530-070N Gas Spring ( D3552 Rev H )
16	B6-220-530-140N Gas Spring ( D3552 Rev H )
20	BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut
20	SSA4/6-122-315-310N Stainless Gas Spring ( D3969 Rev C )
30	SSA4/8-122-310-360N Stainless Gas Spring ( D3969 Rev C )
	Shipping Via FED EX Tracking #795153667815



303 – 103<sup>rd</sup> Street, Saskatoon, Saskatchewan, Canada S7N 1Y9  
Ph: (306) 683-5000 Fax: (306) 683-6403

### Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

12 Units: B8-220-530-070N Gas Spring ( D3552 Rev H ) *S. Ulrich*  
16 Units: B6-220-530-140N Gas Spring ( D3552 Rev H )  
20 Units: BS104 - 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg with Locknut  
20 Units: SSA4/6-122-315-310N Stainless Gas Spring ( D3969 Rev C )  
30 Units: SSA4/8-122-310-360N Stainless Gas Spring ( D3969 Rev C )

**Country of Manufacture: Canada**

**Date of Manufacture : September 2011**

**This product is ROHS compliant.**

**We certify no mercury was used in the manufacture of this order.**

Purchase Order # 14805  
Invoice # 76553

L S Technologies Inc Canada

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Mark Ingram  
Manager